

Work Order ID 131854

131854

Page 1

Tuesday, April 21, 2015 2:07:21 PM

Item ID: D3778-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 4/20/15 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 15-04-22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3778	B								

100 FLOW WATER JET 0.00
100
Waterjet Memo 0.00
FLOW CNC Waterjet 1-Cut as per Dwg D3778
5052.090" Dwg Rev: 0
Prog Rev: B
****grain direction along 2.34" ****
2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
QC Memo 0.00
Quality Control

6 0 Jm15-4-30
6 0 Jm15-4-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER :							

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MAY 01 2015

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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Work Order ID 131854

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 Revision ID: Stop ***NS2***
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 Start Date: 4/20/15 Start Qty: 6.00 ***6*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>6</u>		DAS 28 9-89	DAS 38 9-89 MAY 05 2015
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>st sb</u> Memo	0.00 0.00				<u>60</u>		DAS 27 9-89	<u>Σ</u> MAY 05 2015 MAY 06 2015
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						MLG	MLG MAY 06 2015

DQA: _____ Date: _____



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OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 131854

131854

Parent Item: D3778-1

D3778-1

Parent Item Name: Bracket

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A new issue 08-04-15 DD verified by:EC
IPP Rev:B 08-05-14 revA as per ECN1171 DD verified by:EC
IPP Rev:C 08-05-22 add powder coating DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.090		Purchased			No	100	sf	64.0000	0.0934	0.589895			
M5052H32S 090										**	①	Jm 15-4-30	
5052-H32 .090 Sheet													

Location

Loc Qty

Loc Code

MAT

64

m131392

64

131392

DQA: _____ Date: _____

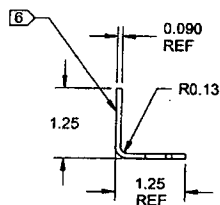


WORK ORDER NON-CONFORMANCE / UPDATE

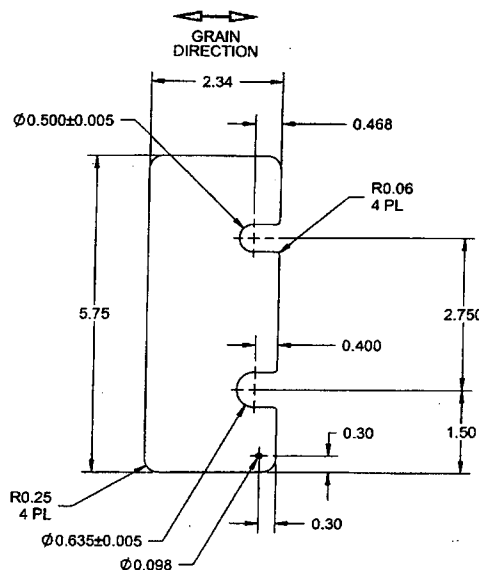
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OTHER : ☐					



D3778-1 BRACKET



D3778-1F FLAT PATTERN



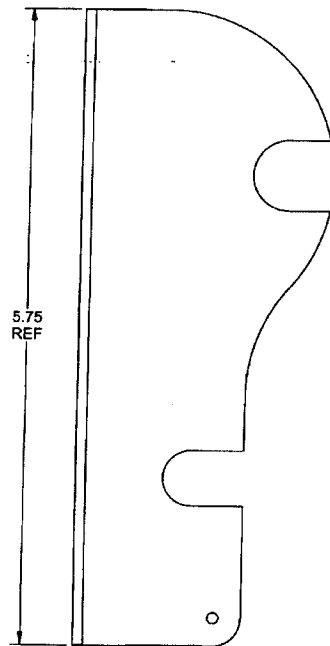
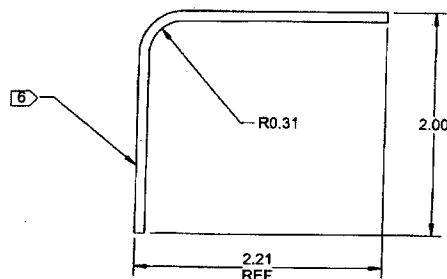
SHO
REF
ENCL
UNCONT
SUBJECT
WIT
NO. 131854 MJS
15-04-22

RELEASED
R 2012-03-30

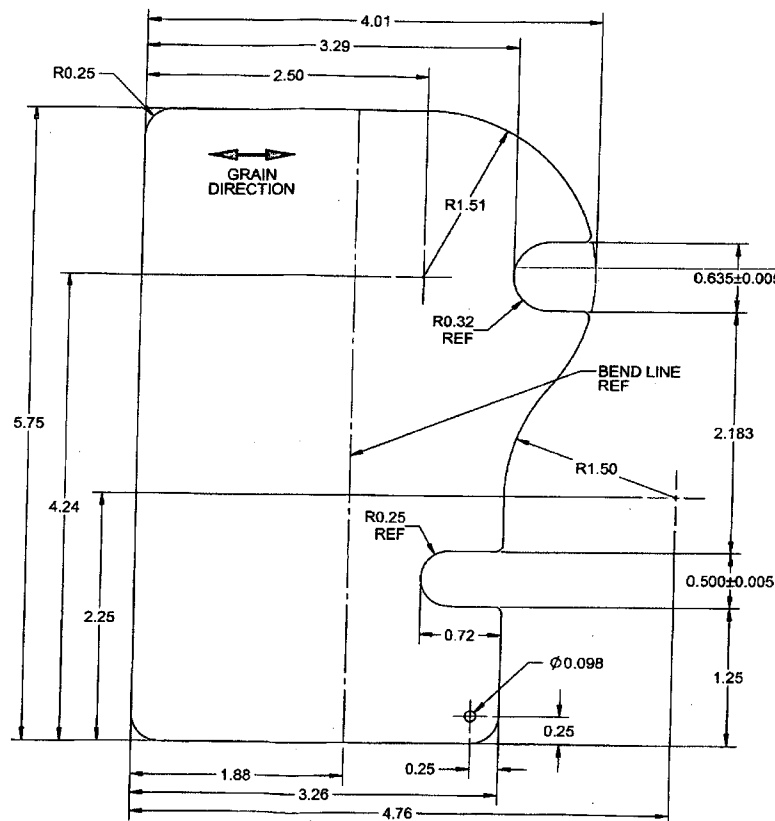
NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32.090) OR 6061-T6/T62 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T60.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3778-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -1: 0.11 lbs
-3: 0.17 lbs

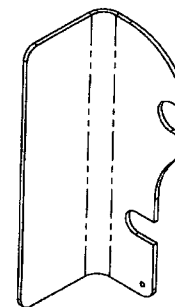
B	ADDED -3 (REF: PAR 12-163)	AJS	12.03.15
A	NEW ISSUE	PH	08.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3778	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	12.03.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUBJECT TO THE LICENSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3778-3 BRACKET



D3778-3F BRACKET
(FLAT PATTERN)



RELEASED
2012-03-30

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3778	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	12.03.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	